

# Work Order ID 84976

**\*84976\***

Page 1

May-30-12 11:25:25 AM

Item ID: D3207-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 5/30/12 Start Qty: 13.00 **\*13\*** Cust Item ID:  
 Required Date: 5/30/12 Req'd Qty: 13.00 **\*13\*** Customer:  
 Reference: NCR12-1454

Approvals: Process Plan: U Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3207	C								
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>	QC								
Quality Control	Memo INSPECT D3207-1 B84130 WAS MADE WRONG REF NCR12-1454	0.00							
180	Identify as per dwg & Stock Location	0.00							
<b>*180*</b>	Packaging								
Packaging	Memo RE-IDENTIFY AND STK AS D3207-1 USING NEW B/N	0.00							
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>	QC								
Quality Control	Memo	0.00							

x12

12x

12-5-30

12/5/30

mk  
12-05-30

# Picklist Print

May-30-12 11:25:24 AM

Page 1

Work Order ID: 84976

Parent Item: D3207-1

Parent Item Name: Bracket

Start Date: 5/30/12

Required Date: 5/30/12

Start Qty: 13.00

Required Qty: 13.00

Comments: IPP A04.04.15New issueKJ/RF  
IPP Rev:B Now On Waterjet 08-01-02 JLM Verified By:DD  
IPP REV C AS PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:D 12.05.10 per dwg  
rev.c DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3207-11 Bracket		Manufactured	No				Each	0.0000		12		8/1/30	

Work Order ID 84130

Thursday, May 03, 2012 11:32:43 AM

NCR 12-1454

84976

\*84130\*

ASAP

Page 1

Item ID: D3207-11

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Bracket

Stop

\*NS2\*

Start Date: 5/3/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/14/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

MUF

Date:

12-05-03

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3207	REV B					(14)			
100	FLOW WATER JET	0.00				✓	0		RIES-7
*100*						✓	0		JM
Waterjet	Memo	0.00							12-5-4
FLOW CNC Waterjet	1-Cut as per Dwg D3207								
2024 .063	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				✓	0		RIES-7
*110*						✓	0		JM
QC	Memo	0.00							12-5-4
Quality Control									

NCR 12-1454

# Work Order ID 84130

Thursday, May 03, 2012 11:32:43 AM

**\*84130\***

Page 2

Item ID: D3207-11

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 5/3/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 5/14/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00	- inspect to PCI						
<b>*120*</b>		0.00	Dwg only						
QC	Memo		8/2/03/02						
Quality Control			(HY)						
130		0.00							
<b>*130*</b>	NC BRAKE	0.00							
Brake NC	Memo								
Brake NC	Form as per Dwg D3207								
	Identify as D3207-11								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O	0.00	- inspect to PCI						
QC	Memo	0.00	Dwg only						
Quality Control			8/2/03/02						
			(HY)						

8/2/03/02

Work Order ID 84130

\*84130\*

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Thursday, May 03, 2012 11:32:43 AM

Item ID: D3207-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 5/3/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/14/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

(14) 2/6 12-5-8

155

QC7-Inspect Chemical Conversion Coat

0.00

\*155\*

QC

Memo

0.00

Quality Control

14X ✓ M-L 12/5/08

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

\*160\*

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:50 OVEN TEMPERATURE:

FINISH TIME:

3200F 3:20

14X ✓ M-L 12/5/08

M 117338

# Work Order ID 84130

Thursday, May 03, 2012 11:32:43 AM

**\*84130\***

Page 4

Item ID: D3207-11

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 5/3/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 5/14/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>202</u>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

Reinspected to Back Drum  
Dizlo/10/10 (714)

H.  $\phi$  12.5.8

140 10/5/10

12/5/10

MF  
12-0510

# Picklist Print

Thursday, May 03, 2012 11:32:42 AM

Page 1

Work Order ID: 84130

Parent Item: D3207-11

Parent Item Name: Bracket

Start Date: 5/3/2012

Required Date: 5/14/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12-03-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No				sf	379.4000		1.0168421	(14)		

Location

Loc Qty

Loc Code

MAT022

379.4

119916

144.4

121197

235

119916

B12-5-7

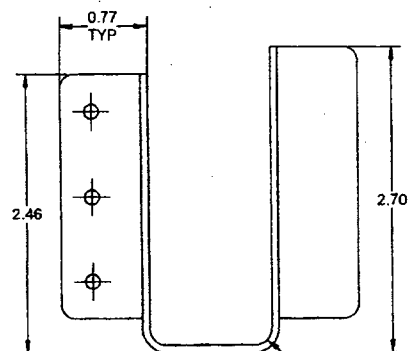
119916

JM

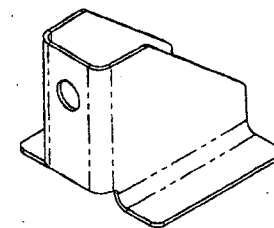
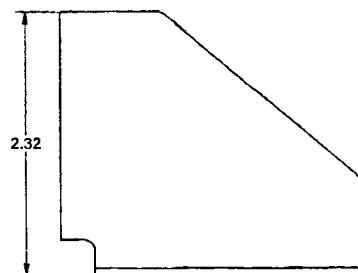
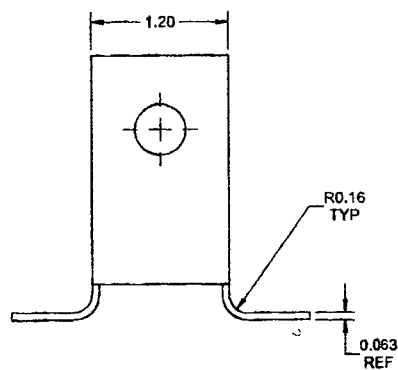
12-5-7

~~119916~~

11.02



R0.16  
TYP



#84130

# **D3207-11 BRACKET**

**PRELIMINARY ISSUE**

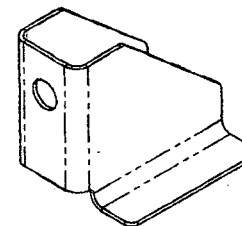
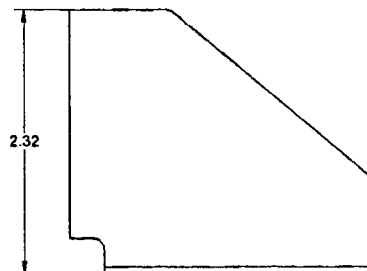
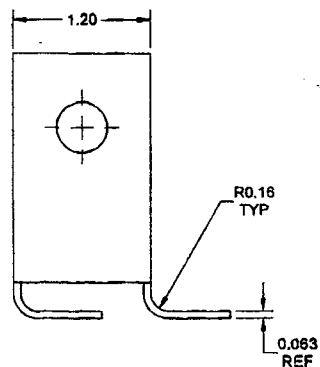
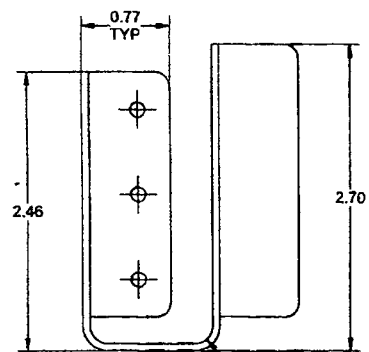
# 12.05.04

## **NOTES:**

- 1) MATERIAL: MAKE FROM D3207-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		<b>D3207</b>	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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#84130

# **D3207-1 BRACKET**

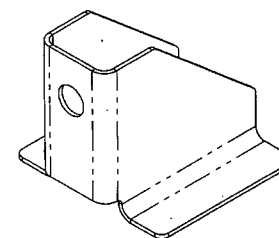
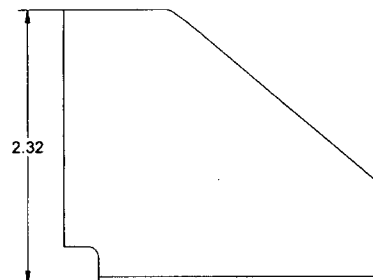
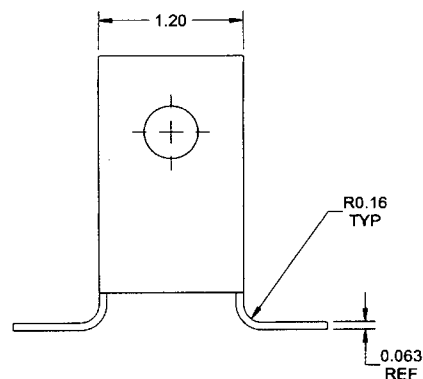
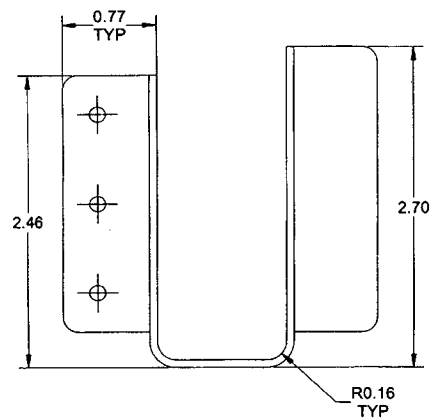
**PRELIMINARY ISSUE**

12.05.04

## **NOTES:**

- 1) MATERIAL: MAKE FROM D3207-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

C	REVISE D3207-1F (ZN B5-2)	RF	12.05.04
B	CONVERT DRAWING TO STANDARD FORMAT; RE-DESIGN D3207-1, 1F (ZN A5-4, A5-2); MATERIAL THICKNESS 0.063 WAS 0.050 (ZN A5-2); REMOVE D3207-2, ADD D3207-7 (ZN B5-7), D3207-8 (ZN A5-8) & D3207-11 (ZN A5-10) PER PART 12-162	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. PC1
MFG. APPR.		<b>D3207</b>	SHEET 1 OF 10
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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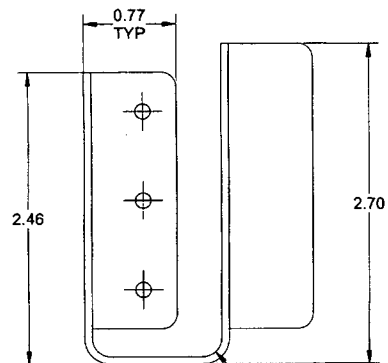
**D3207-11 BRACKET**

**NOTES:**

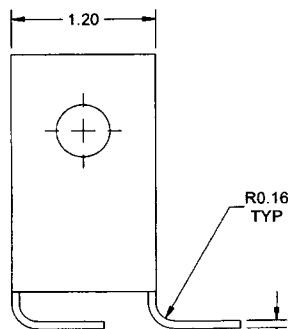
- 1) MATERIAL: MAKE FROM D3207-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3207</b>	SHEET 10 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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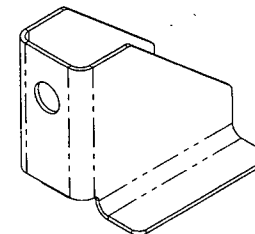
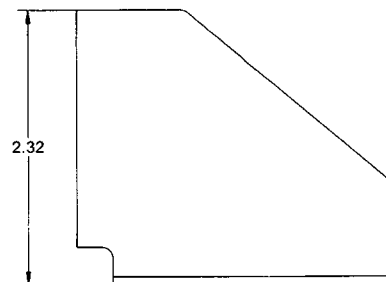
**RELEASED**  
2012-05-09  
*MP*



R0.16  
TYP



0.063  
REF



# **D3207-1 BRACKET**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D3207-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

**RELEASED**  
2012-05-09

C	REVISE D3207-1F (ZN B5-2)	RF	12.05.04
B	CONVERT DRAWING TO STANDARD FORMAT: RE-DESIGN D3207-1 -1F (ZN A5-1, A5-2); MATERIAL THICKNESS 0.063 WAS 0.050 (ZN A8-2); REMOVE D3207-2; ADD D3207-7 (ZN B5-7), D3207-9 (ZN A5-8) & D3207-11 (ZN A5-10) PER PAR12-182	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3207	SHEET 1 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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